Work Order ID 54729-

December 17, 2009 11:34:31 AM



Page 1

Item ID:

D3929-041 44



Accept



Setup Start

Stop



Revision ID:

Item Name: Gusset Assembly

Required Date: 23/12/2009

Start Date:

17/12/2009

Start Qty: (6.00 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Revision Nbr

Tooling:

Date:

Start Run

Stop



Sequence ID/

QC:

Date:

SPC (Y/N):

Date:

Reject Reject Insp. Qty Number

Work Center ID Draw Nbr

Operation Description Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Code

Accept Qty

Stamp

D3929

Rev A

100

Waterjet FLOW CNC Waterjet Memo

1-Cut as per Dwg D3929

Dwg Rev: Prog Rev:

0.00

0.00

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1B 10-1-4

Quality Control

Dart Aerospace Ltd W/O: WORK ORDER CHANGES Approval Approval STEP DATE PROCEDURE CHANGE By Chief Eng / Date Qty QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Description of NC Verification Approval Approval STEP DATE Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Chief Eng Chief Eng Date

December 17, 2009 11:34:31 AM

Item ID:

D3929-041 -

Revision ID:

Item Name:

Gusset Assembly

Start Date:

17/12/2009

Start Qty: 6.00 Req'd Qty: 6.00

Required Date: 23/12/2009

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Run

Start

Stop



Approvals:

Reference:

Process Plan:

QC:

Date: Date: Tooling: SPC (Y/N):

Draw

Date:

Draw

Rev.

Date:

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/

Run Hours

0.00

0.00

Number

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

130



Packaging

Pick Kit

0.00

0.00

0.00

0.00

PD

10.01.05

140



Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

316L rod batch: H109213

10.01.05



Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/0:54729		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	*Approval QC Inspector			
	140	6 packs on this who + 3 parts of split -2 who				N				

Part No: 03929-041	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		¥)	WORK ORDI	ER NON-CONFORMAN	CE (NCR)				
	0777	Description of NC		Corrective Action Section B	3	Verification Appro		al Approval	
DATE STEP		Section A			Section C				
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				\$					
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Work Order ID 54729



December 17, 2009 11:34:32 AM

Item ID:

D3929-041 -7

Revision ID:

Item Name:

Gusset Assembly

Start Date:

17/12/2009

Start Qty: 6.00 Required Date: 25/12/2009

Reference:

Req'd Qty: 6.00



Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run

Start

Stop

Approvals:

Process Plan:

QC:

Date: Date: Tooling: SPC (Y/N):

Date:

Date:

Sequence ID/ Work Center ID

150

Quality Control

Operation Description

OC9- Inspect visual per QS1004- Fusion Welds

Memo

Set Up/ Run Hours

0.00

0.00

Draw Number Draw Rev.

Plan Qty Code

Reject Accept Qty

Reject Number Stamp

Insp.

160

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

46

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Busket cell

Memo

Memo

0.00

0.00

St 10/01/06

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PR	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	16								
	- a	<u>, </u>					70		
Part No		PAR #:							
NOD	nes	olution:		DER NON-CONFORMA				Date: _	-
NCR:			WOTH OTH		10%	1)			
DATE	STEP	Description of NC		Action Description	on B Sign		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector
			51 (*)						

Work Order ID 54729

Page 4

December 17, 2009 11:34:32 AM

Item ID:

Gusset Assembly

D3929-041 -

Revision ID:

Item Name: Start Date:

17/12/2009

Start Qty: 6.00

Operation

Description

Required Date: 23/12/2009

Req'd Qty: 6.00

Accept

Setup Start

Stop

Reference:

Approvals:

Process Plan:

Date:

QC21- Final Inspection - Work Order Release

Tooling:

Date:

Cust Item ID:

Customer:

Run

Start

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

180

Memo

0.00

0.00

Draw Number Draw Rev.

Plan Qty Code

Reject Accept Qty

Reject Number

Insp. Stamp

Quality Control

Dart Aerospace Ltd

	ACCOUNT OF THE PARTY OF THE PAR									1.0	
W/O:			WC	RK ORDER CHANG	ES				RI		
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cate	gory:	NCF	l: Yes I	No DQ	A:	Date:		
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NCR:			WORK ORDI	ER NON-CONFORMA	ANCE	(NCR					
DATE	STEP	Description of NC	of NC Corrective Action				Verific	ation	Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C				Chief Eng	QC Inspector
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					,					e H	

Picklist Print

· December 17, 2009 11:34:36 AM

Work Order ID: 54729

Parent Item: D3929-041

Parent Item Name: Gusset Assembly

Comments:



Start Date: 17/12/2009

Required Date: 23/12/2009

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Measure	Qty on Hand	Remaining Qty To Pic		Date Issued	Status
M304S11GA		Purchased	No			100	sf	107.0791	2.8421	4.3	1B 10-1-4	
				Warehou	ise	Loc	Qty	Loc Code				
				Loca	tion							
				Main Wa	rehouse							
				MAT		107	.0791					
					112663	107	.0791			112663		- K
D3907-1		Manufactured	No			130	Each	57.0000	12.0000			

Bushing

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	17	
53673	17	
Main Warehouse		
WA	40	
54042	40	

PD 10,01.05

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Don't No										
Part No		PAR #:								
	Re	esolution:							Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR)			•	
DATE	STEP	Description of NC	Description of NC Corrective Action				Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng			Sign & Date	ign & Section C		Chief Eng	QC Inspector
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			(4							
										6
			1				1			

DART AEROSPACE LTD	Work Order:	54729
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	x	First Artic	le	Proto	ototype			
Drawing 3.	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Ø0.375	+0.006/-0.001	375	8			17		
0.500	+/-0.010	SOI				70		
0.500	+/-0.010	.503	× ×					
4.036	+/-0.010	4.040	8			1927		
4.382	+/-0.010	4.385	y			WY.		
8.274	+/-0.010	8.576	7			12/0		
10.915	+/-0.010	10-911	×			100		
1.000	+/-0.010	1,007	8			ae m		
11.198	+/-0.010	11.700	7					
0.500	+/-0.010	,505	>			5 10		
1.572	+/-0.010	1.572	8			AND LINE WATER		
0.125	+/-0.010	- [1]	y			0.0		
1143								
8								
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						in the last of the		
		Name - And State						
11		and the second						
68.74		and the same				1,00%		

Measured by:	10	Audited by:	5	Prototype Approval:	N/A
Date:	18-1-4	Date:	coloclot	Date:	N/A

Rev	Date	Change		Revised by	Approved
		New Issue	P/O D3929-041/-042	KJ KJ	X

DATE	STEP	PRO	CEDURE CHAP	RK ORDER CHANGES	1112		T	Approval	1
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								0	
	18	* 1			800				
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	Re	solution:			A: N/C			Date: _	
NCR:		V	WORK ORDE	ER NON-CONFORMANO	CE (NC	R)			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Approval Chief Eng	Approval QC Inspecto
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QTY -041 QTY -042 DESCRIPTION ITEM P/N D3929-041 **GUSSET ASSEMBLY GUSSET ASSEMBLY** D3929-042 BUSHING D3907-1 D3929-1 SUPPORT GUSSET 12

D3929-042 GUSSET ASSEMBLY

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COFY SUBJECT TO AMENDMENT WITHOUT NOTICE

A	NEWIS	SUE	MB 09.04					
REV			DESCRIPTION	BY DAT				
DESIGN DRAWN		44	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
		3						
CHECKED PA		Pat	DRAWING NO.	REV. A				
		M	D3929		SHEET 1 OF 3			
APPROVED AND		11/10	TITLE		SCALE			
DE APPR.		4	GUSSET ASSEMBLY	NTS				
DATE	09.0	04.03	THE DOCUMENT IS THE OFFICE OF THE OWNER OF THE OWNER OF THE OWNER OF THE OWNER					

NOTES:

(1) MATERIAL: N/A

(2) FINISH: N/A

(3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

(3) UNITS: INCHES UNLESS OTHERWISE NOTED

(4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

(5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX)) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
) WEIGHT: 0.73 IDS EACH

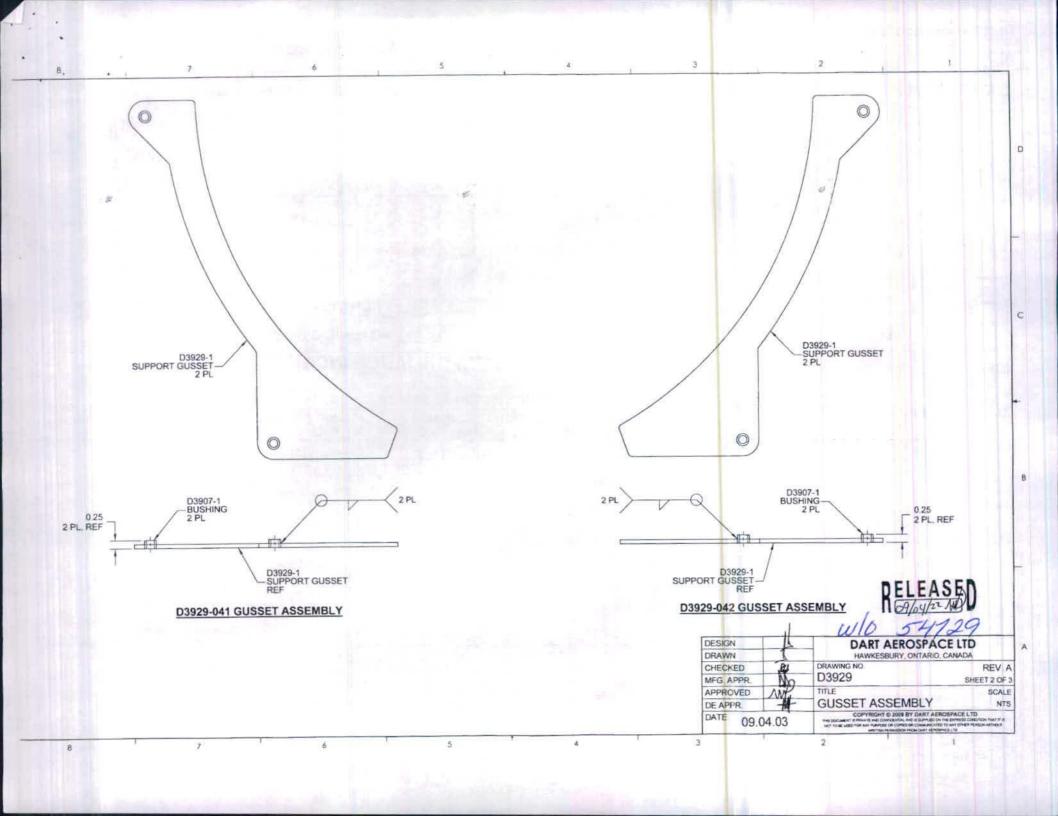
D3929-041 GUSSET ASSEMBLY

3) WELDING: PER DART QSI 004

C

Dart Aerospace Ltd

		WO	RK ORDER CHANGE	S				
STEP	PRO	OCEDURE CHAP	IGE	Ву	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Dart Aerospace Ltd W/O: WORK ORDER CHANGES Approval Approval' DATE STEP PROCEDURE CHANGE By Date Qtv Chief Eng / Prod Mgr QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ___ Resolution: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) NCR.

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		Description of NC	Description of NC Corrective Action Section B				Ammunual						
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3 2.780 - 0.250 1.572 -D 0.500 R0.50 2 PL R12.00 10.915 1.000 TYP R0.13 TYP Ø0.375^{+0.005} 2 PL 70° REF 0.500 -- 0.500 4.036 4.382 8.274 D3929-1 SUPPORT GUSSET DESIGN DART AEROSPACE LTD NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 11 GAUGE (0.125 THICK) REF. DART SPEC. M304S11GA HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3929 MFG. APPR SHEET 3 OF 3 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
1) UNITS: INCHES UNLESS OTHERWISE NOTED TITLE **APPROVED** SCALE **GUSSET ASSEMBLY** NTS DE APPR 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 3) IDENTIFICATION: N/A COPYRIGHT 6 2005 BY DART AEROSPACE LTD.
THE EXCHANGE IS MINIST AND COMPRESS, AND IS SUPPLYED TO THE DARKS CONDITION OF THE PROPERTY OF THE PRO DATE 09.04.03 7) WEIGHT: 0.72 lbs 2

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

Approval* QC Inspector

Part No		PAR #:	Fault Category: NCI		NCR: Yes N	o DQA:	Date:			
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NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)							
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